

CLAIM AMENDMENTS

Claim 1. (currently amended) A method for forming, in a production line, profiles (50) with a cross-section that varies along the length thereof, said profiles being formed from a plane metal strip (10) that is unwound from a coil (9), whereby said method employing edge cutters (14) and a number plurality of roll-forming units (17 - 24), are used where not only the edge cutters but also and the roll-forming units can be displaced being individually displaceable sideways relative to the strip,

the steps of said method comprising:

controlling the roll-forming units for forming a first corner (53, 56) to each side of the center of said metal strip (10) in a first roll-forming section of said production line, and

controlling the roll-forming units to form a second corner (54, 58) to each side of the center of said metal strip between said first corners, after said first corners have been formed.

characterised in that

the edge cutters (14) and the roll-forming units (17 - 24) are individually controlled such that they follow the lines of extent of the side edges (51, 52) that are cut for the corners (53 - 56) that are subsequently formed, and that the forming of

~~one corner with a number of roll forming units is begun only after the forming of a corner that lies more closely to the edge of the strip has been completed.~~

Claim 2. (currently amended) The method according to claim 1, ~~characterised in that further including the steps of cutting a transverse slit (61, 62) is cut in the strip (10) in the line before forming the first and second corners, the roll-forming operation, without fully cutting off severing the strip, and in that severing the strip with a terminal cutter (30) cuts off the strip after the first and second corners are formed roll-forming operation in order to cut off the remove a trailing end from the length of a said profile formed length manufactured from the strip.~~

Claim 3. (currently amended) The method according to claim 2, ~~in which the characterised in that lengths of the profile are manufactured that formed have different widths of extent at their two ends, whereby opposed ends of said profile, the steps of said method including adjusting the width of the strip is adjusted between one slit (60) that defines the trailing end of one the length of one said profile, and cutting a further slit (61) that is cut in order to define the a leading end of the subsequent length of a subsequent said profile, and then thereafter cutting the strip is cut at both said slits in with the subsequent terminal cutter (30).~~

Claim 4. (currently amended) The method according to claim 1, further including the steps of thinning a portion of the characterised in that sections of the profile sheet are rolled in by a pair of rollers (83, 85; 84, 82) for bending the profile as said profile to become thinner as the roll formed profile (50) is fed forwards in the production line, such that the profile becomes bent.

Claim 5. (currently amended) The method according to claim 4, further including the steps of controlling the bending of the profile by varying a gap between said pair of rollers (83, 85; 84, 82) through which said profile passes characterised in that the roller gap of a pair of rollers (83, 85; 84, 82) that roll the plate thinner is varied as the profile (50) is fed forwards in the production line order to control the degree of bending.

Claim 6. (currently amended) The method according to claim 4, characterised in that a further including the steps of forming the profile (50) is formed with a central flange (76) and flanking pieces (77,79) as the strip (10) is fed forwards in the production line, and thinning one end of each said flanking piece by rolling both flanking pieces are rolled thinner at one end of the flanking pieces.

Claim 7. (currently amended) The method according to claim 4, further including the steps of forming the characterised in that a profile (50) is formed with a central flange (76) and

flanking pieces (77, 79) as the strip is fed forwards in the production line, and one thinning a complete one of said flanking pieces by rolling piece is rolled to become thinner .

Claim 8. (currently amended) The method according to claim 5, characterised in that further including the step of controlling the positions of the pair of rollers roller pairs (83, 85; 84, 82) are controlled by the profile.

Claim 9. (withdrawn) A production line for the continuous forming of profiles that have a cross-section that varies along the length from a plane metal strip (10) that is unwound from a coil (9), comprising an unwinder (11), an alignment device (12), a stamp (13) for the transverse cutting of the strip, and an edge cutter station (14) for cutting the edges of the strip, followed by a roll-forming section (17 - 24), whereby the edge cutter station and the roll-forming unit can be individually displaced and guided in a sideways direction in order to vary continuously the final appearance of the profile (50) that is being manufactured

characterised by

a bending station (25) after the roll-forming section (17 - 24), that comprises rollers (35 - 40) that can be guided to roll sections of the profile (50) to become thinner such that the profile is in this way bent or twisted as it is formed.

Claim 10. (withdrawn) The production line according to claim 9, characterised in that the bending station (25) comprises a pair of rollers (83, 85; 84, 82) on each side of the profile.

Claim 11. (withdrawn) The production line according to claim 10, characterised in that the pairs of rollers are mounted such that they can be displaced, and are connected to means arranged to be guided by the profile (50).

Claim 12. (withdrawn) The production line according to claim 10, characterised in that the bending station comprises two bending units (26, 27), one mounted after the other along the line.

Claim 13. (currently amended) The method according to claim 5, ~~characterised in that a further including the steps of forming the profile (50) is formed~~ with a central flange (76) and flanking pieces (77, 79) as the strip (10) is fed forwards in the production line, and thinning one end of each said flanking piece by rolling ~~both flanking pieces are rolled thinner at one end of the flanking pieces~~.

Claim 14. (currently amended) The method according to claim 5, further including the steps of forming the ~~characterised in that a profile (50) is formed~~ with a central flange (76) and flanking pieces (77, 79) as the strip is fed forwards in the

production line, and one thinning a complete one of said flanking pieces by rolling piece is rolled to become thinner .

Claim 15. (currently amended) The method according to claim 6, characterised in that further including the step of controlling the positions of the pair of rollers roller pairs (83, 85; 84, 82) are controlled by the profile.

Claim 16. (currently amended) The method according to claim 7, characterised in that further including the step of controlling the positions of the pair of rollers roller pairs (83, 85; 84, 82) are controlled by the profile.

Claim 17. (currently amended) The method according to claim 13, characterised in that further including the step of controlling the positions of the pair of rollers roller pairs (83, 85; 84, 82) are controlled by the profile.

Claim 18. (currently amended) The method according to claim 14, characterised in that further including the step of controlling the positions of the pair of rollers roller pairs (83, 85; 84, 82) are controlled by the profile.

Claim 19. (withdrawn) The production line according to claim 11, characterised in that the bending station comprises two bending units (26, 27), one mounted after the other along the line.

SPECIFICATION AMENDMENTS

Enclosed is a Replacement Paragraph for the paragraph beginning at page 3, line 30, and continuing through page 4, line 18 of the original Specification.